

Date: Tuesday, 19/08/2008 4:07:04 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: UPPER PAD ASSY		
Job Number	: 41505					
Estimate Number	: 13416					
P.O. Number	:			Part Number	: PB674300133	
This Issue	: 19/08/2008		S.O. No.	: B6743001 P.41		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 40294			Drawing Revision	: B1	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08.8.20</u>			Due Date	: 18/09/2008	
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec			Qty:	20	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
		Comment: Qty.: 0.3217 sf(s)/Unit Total : 6.4344 sf(s) 2024-T3 .032 sheet batch: <u>106272X4</u> <u>HB 8-9-2</u> <u>108595X</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001-325 ***Use cutting file -325***** Dwg Rev: <u>B1</u> <u>HB 8-9-2</u> <u>(21)</u> Prog Rev: <u>B1</u>
		2-Deburr if necessary <u>HB 8-9-2</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-9-2</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <u>5/08/08 (21) counter</u>
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <u>5/08/08 (21) RKO</u>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- counter sink rivet holes as per dwg <u>E/B 8/08/08 (20)</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-33 PAR #: N/A Fault Category: Prod / Ass' med & small NCR: Yes No DQA: D Date: 08/10/03

Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 08/10/03

NCR: 41505		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/08	S	Found at the countersink 1 piece was side was damaged.	R 09/09/08	Scrap + destroy	08/09/08	C 09/09/08	R 09/09/08	J 09/09/08

NOTE: Date & initial all entries

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Job Number: 41505		Part Number: PB674300133
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		S 08/08/08 X 20
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		08-08-08 X 20
8.0	POWDER COATING	POWDER COATING  M 10 2316
Comment: POWDER COATING Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3		20X
START TIME: 8:50 AM		oven temperature: 325°F
OVEN TEMPERATURE: 325°F		FINISH TIME: 9:20
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08/08/08 20
10.0	MS20426AD34	RIVET 
Comment: Qty.: 10.0000 Each(s)/Unit Total : 200.0000 Each(s) RIVET batch: M 10 5978		20
11.0	MS21075L3	Nutplate 
Comment: Qty.: 5.0000 Each(s)/Unit Total : 100.0000 Each(s) Nutplate batch: M 12 9068		10 8/9/08 20
12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per dwg B67-43001		E 08/09/15 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: UPPER PAD ASSY

Job Number: 41505

Part Number: PB674300133

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/01/08 120

Comment: INSPECT WORK TO CURRENT STEP

14.0 PG

PURCHASING



8/08/08

Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

C 08/09/10 20

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

P 08/09/08 20

16.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/09/30 120

17.0 PACKAGING 1

PACKAGING RESOURCE #1



120

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 510

8/9/30

30

18.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/02 10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

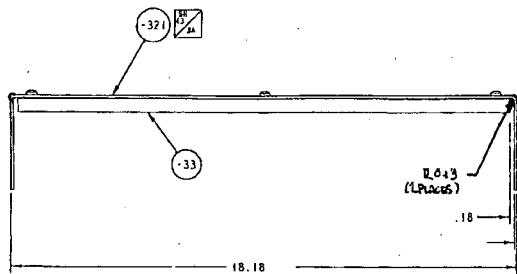
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
06.01.20

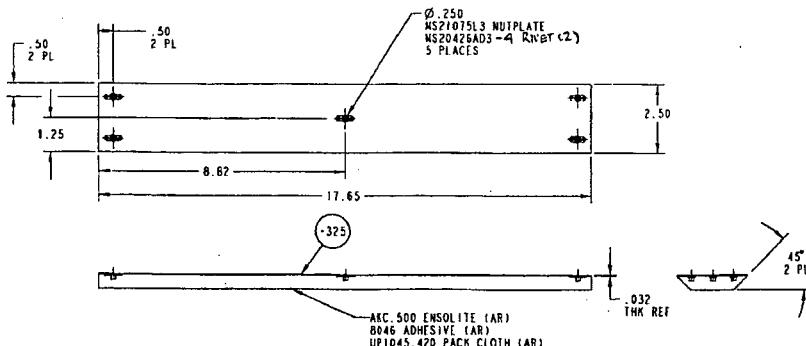
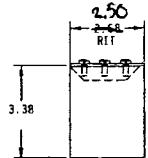


Ø .193 THRU
MATCH DRILL WITH
EXISTING NUTPLATE
LOC'S OF .33
MS27039-1-09 SCREW
NAS1149T0316P WASHER
5 PLACES



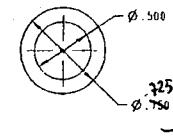
① -31 UPPER RESTRAINT WELDMENT

SCALE 0.500



① -33 UPPER PAD ASSY

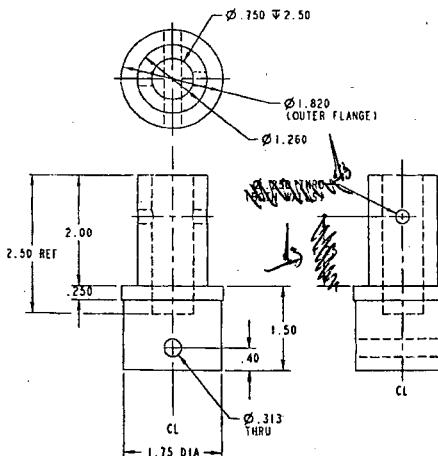
SCALE 0.500
MATERIAL FOR -325: .032 THK 2024-T3 AL.
QQ-A-250/4



④ -299 BUSHING

SCALE 2.000

MAT: 304 CRES. COND A



① -305 BEARING

SCALE 1.000
MATERIAL: 2024-T3 AL.
QQ-A-200/3

PREMIER AVIATION, INC.
100 Aviation Parkway, Great Prairie, Texas 75046
DATE ISSUED: 06/01/2020
DRAWING NO.: B67-43001
SCALE: 1:1
B1

ORIGINAL

NO 4150
W/ NO 1000
SHEET COPY
RETURN TO
ENGINEERING
AMENDMENT
SUBJECT TO
NOTICE
WITHOUT
UNCC'D/STRUCK/COPY

DART AEROSPACE LTD	Work Order:	41505 325
Description: UPPER PAD ASSY	Part Number:	PR6743001-13
Inspection Dwg:	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>RS</u>	Audited by: <u>CD</u>	Prototype Approval: <u>1</u> / <u>0</u>
Date: <u>8-9-2</u>	Date: <u>08/08/02</u>	Date: <u>08</u>

Rev	Date	Change	P/O B67-43001-33	Revised by	Approved
A		New Issue		KJ/JLM	

P/O B67-43001-33

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RELEASE NOTE

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : CATULSAF1123HAW
www.tulmar.com
email: info@tulmar.com

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Ship To:

Dart Aerospace
1270 Aberdeen Street
Call: Chantal Lavoie
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order No.	Order Date	Customer No.	Sales Rep.
21962	16-Sep-08	CDART100	Barney Bangs
Customer PO Number		Ship Via	Packing Slip No.
PO00007171		Pick-Up	30213
Item No.	Qty	UOM	Qty Shipped/Returned
Description			Qty Backordered
8421-107	20	EA	20
Dart Blade Fold Kit - Pad #8/ Drawing No: (Ref B67-43001-33 Rev B1) DWG Rev: NR			
Comments:			
Lot No: BATCH0000000004 Qty: 20			
<i>S 08/04/08</i>			
8421-109	9	EA	9
Dart Blade Fold Kit - Pad #10/ Drawing No: (Ref B67-43001-35 Rev B1) DWG Rev: A			
Comments:			
Lot No: BATCH0000000004 Qty: 9			
8421-104	20	EA	20
Dart Blade Fold Kit - Pad #5/ Drawing No: (Ref B67-43001-173 Rev B1) DWG Rev: A			
Comments:			
Lot No: BATCH0000000006 Qty: 20			
8421-103	20	EA	20
Dart Blade Fold Kit - Pad #4/ Drawing No: (Ref B67-43001-181 Rev B1) DWG Rev: A			
Comments:			
Lot No: BATCH0000000004 Qty: 20			
8421-108	12	EA	12
Dart Blade Fold Kit - Pad #9/ Drawing No: (Ref B67-43001-267 Rev B1) DWG Rev: NR			
Comments:			

Release Note No.
R92-30213

Ship Date

26-Sep-08



J. ENNIS FABRICS LTD.

Wholesale Distributor of Textiles and Supplies

October 20, 2006

Fax To: Tulmar Safety Systems
Fax: 613-632-2030
Attention: Sandra Nadeau
Fax From: Deanna Penner

EDMONTON
HEAD OFFICE
12122-68 Street
Edmonton AB T5B 1R1
Canada
Phone: (780) 474-5721

Certificate of Conformance

Re: PO 11878 for Oxford 7 Black

The goods shipped on P/O 11878 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd
Content: 100% Nylon

Coating: Product has a Polyurethane Coating {approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.)}
Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Manufacture Date: 1) 50 yds each 9/11/06 Piece # 101629822, 101629830, 101629848,
101630226, 101630234, 101630275 & 101630283 &
2) 50 yds each 10/12/06 Piece # 101734465, 101734473, 101734481, 101734499 & 101734507.

Lot Number: 1) 50 yds each, #217079 Piece # 101629822, 101629830, 101629848, 101630226,
101630234, 101630275 & 101630283
2) 50 yds each, #221709 Piece # 101734465, 101734473, 101734481, 101734499 & 101734507.

Sincerely,
J. Ennis Fabrics Ltd.

D. Penner

Deanna Penner
Product Development

English: 1-800-66-ENNIS

Fax: (780) 479-6135
www.jennisfabrics.com

Français: 1-888-66-ENNIS

— # 1105 / 11

RELEASE NOTE

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID: CATULSAF1123HAW
www.tulmar.com
Email: info@tulmar.com

B/I No:

Dart Aerospace
1170 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Release Note No.
R92-30213
Ship Date

26-Sep-08

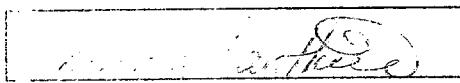
Ship To:

Dart Aerospace
1270 Aberdeen Street
Call: Chantal Lavoie
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order No.	Order Date	Customer No.	Sales Rep.
21962	16-Sep-08	CDART100	Barney Bangs
Customer PO Number		Ship Via	Packing Slip No.
PO00007171		Pick-Up	30213
Item No.	Qty	UOM	Qty Shipped/Returned
Description			Qty Backordered
Lot No: BATCH0000000003 Qty: 12			

If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

This release note is a Certificate of Conformance and I hereby certify that the items listed hereon have been inspected, tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this release note is on file, and can be made available upon request.



Authorized Inspector

09/26/2008

Date